: BRACKET ASSEMBLY

: D3121141

: 24/11/2008

: N/A

: E

. D3121 REV E

Monday, 17/11/2008 11:52:31 AM

User:

Julie Dawson

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Type

S.O. No. :

: 43484 : 10278

Estimate Number

P.O. Number

This Issue

: 17/11/2008 : NC

Prsht Rev. : 11

First Issue

: 42189 **Previous Run**

Written By

Comment ·

Checked & Approved By

: Est Rev:Pick:A 04.02.18 New issue KJ/DS

Est Rev:B ECN 1060 07-11-12 DD verified by: EC

: MACHINED PARTS

Est Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified

By:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M174B1250X02000 17-4 SS Bar 1.250 x 2.00

NOT ENGUEH MATI

IN COMPUTER

Each

Comment: Qty.:

0.5775 f(s)/Unit Total: 13.8600 f(s) Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.250x02.000)

Identify for D3121-111

13.8600 ((s) 6604/5643 M109021X2 = 11

2.0



Comment: BAND SAW

Cut blanks: (1.250" x 2.000") 6.600" long

3.0

HAAS1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121Identify as D3121-111

2-Deburr .

3-Scribe batch number

4.0

QC2

INSPECT PARTS AS THEY COME OFF MAC



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Dart	Aeros	pace	Ltd

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DATE	STEP		PROC	EDURE CH	HANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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DATE	CTED	Description of NC		Corrective Action Section			n B		Verific	ation	Approval	Approval		
DATE	STEP	Section A		_	Initial Chief Eng	Ad	ction Desc Chief Eng		Sigr Da		Section C		Chief Eng	QC Inspector
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Date: Monday, 17/11/2008 11:52:31 AM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: BRACKET ASSEMBLY** Job Number: 43484 Part Number: D3121141 Job Number: Seq. #: **Machine Or Operation:** Description: 5.0 QC8 SECOND CHECK Comment: SECOND CHECK 6.0 D312121 Bolt Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s) Pick: Description Batch **Qty Part Number** 1 D3121-21 08/12/08 7.0 D3121241 Bearing Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 24,0000 Each(s) Pick: **Qty Part Number** Description Batch 1 D3121-241 Bearing Ass SMALL FAB 1 8.0 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble D3121-141 as per Dwg D3121. 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 QC21 08/12/11 Comment: FINAL INSPECTION/W/O RELEASE MF 08-12-16 Job Completion

Form: rprocess

Page 2

W/O:

DATE	STEP	PR	OCEDURE CHANGE	•	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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WORK ORDER CHANGES

WORK ORDER NON-CONFORMANCE (NCR)								
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DART AEROSPACE LTD	Work Order:	7348H
Description: Bracket	Part Number:	D3121-111
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	\$ 393	1			:
0.75	+/-0.030	744"				
0.375	+/-0.010	37/		·		
2.14	- +/-0.030	2,140				
1.96	+/-0.030	1.965				
0.280	+/-0.010	284"				
3.330	+/-0.010	3 320	V			· · · · · · · · · · · · · · · · · · ·
3.630	+/-0.010	3,633"	1/			
R0.25	+/-0.030	Ro. 2500				
R0.375	+/-0.010	RO. 375				٠.
Ø0.201	+0.005/-0.001	\$ 200"				
0.100	+/-0.010	./00^				
4.580	+/-0.010	4,583				
6.18	+/-0.030	6,182		-		
5.89	+/-0.030	5,897				
0.080	+/-0.010	,080"				
0.300	+/-0.010	,300'				
30°	+/-0.1°	30°	1			
R0.25	+/-0.030	B. 250"				
0.130	+/-0.010	126		-		
0.664	+/-0.010	:664"		-		
0.381	+/-0.010	390				
0.201	+/-0.010	,203				
0.400	+/-0.010	,394"				-
0.580	+/-0.010	583				
100°	+/-0.1°	100°				
0.032	+0.000/-0.010	ر030 الم				

Measured by:	J.F.	Audited by:	ゴム	Prototype Approval:	N/A
Date:	08//2/01	Date:	08/12/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
_ A	04.01.12	New Issue P/O D3121-141	KJ/RF	
В	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
Е	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	13/

Dart Aerospace	Ltd
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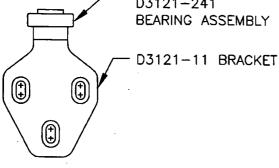
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I	DATE			TITLE SCALE					
	07.1	1.07		BRACKET ASSEMBLY 1:2					
	Α		02.04.15	NEW ISSUE					
	В		03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146					
	С		04.02.17	ADD CLEARANCE; USE -241 BEARING					
	D		06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000					
	Ε		07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)					



D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1)

D3121-041 BRACKET ASSEMBLY

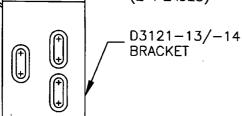
(REPLACES PREMIER P/N B30-23000-33)



- D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1) (2 PLACES)

(1) <u>D3121-043 (SHOWN) / D3121-044 (OPPOSITE)</u>
<u>BRACKET ASSEMBLY</u>

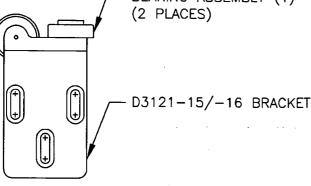
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D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1) (2 PLACES)

D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)



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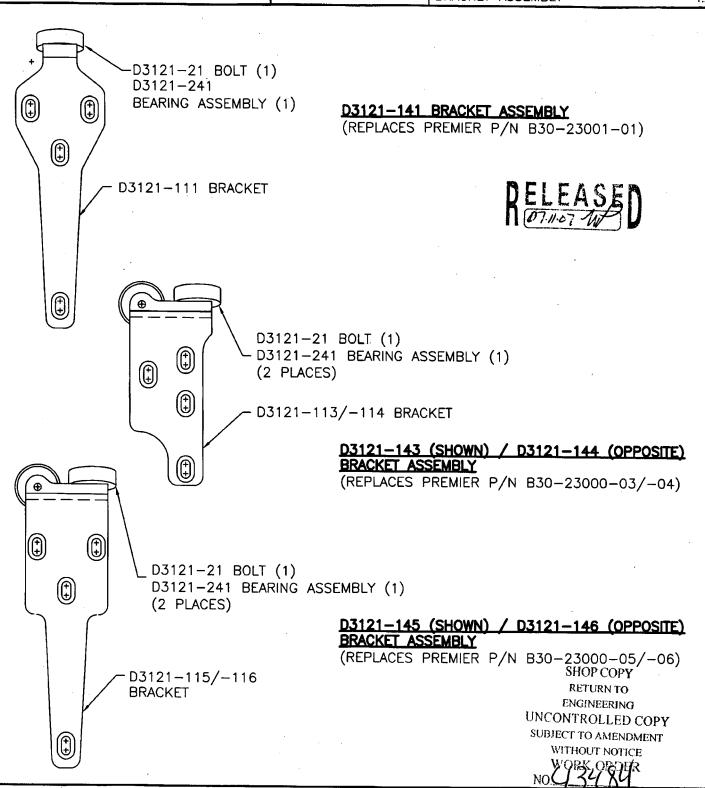
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07.11.07		BRACKET ASSEMBLY	1.2



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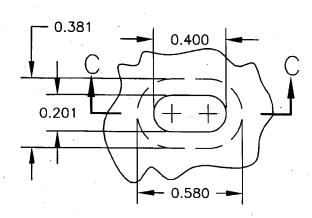
WORK ORDER CHANGES

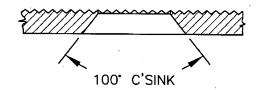
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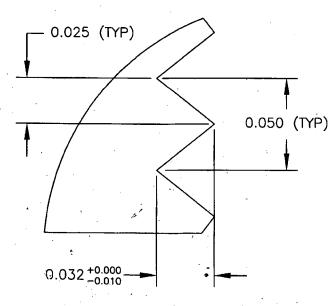
DETAIL A: SLOT DETAIL SCALE 2:1 VIEW ROTATED





RELEASED

DETAIL B: RIDGE DETAIL PARTIAL SECTION **SCALE 1:20**



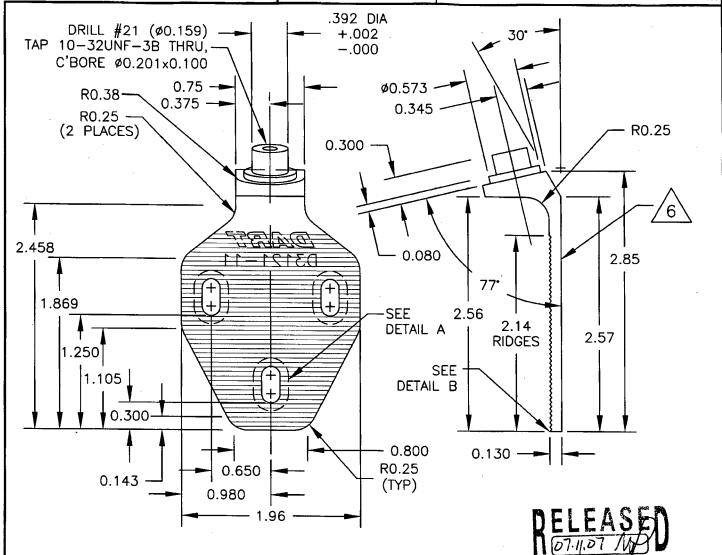
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#	- #	D3121		SHEET 4 OF 10			
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07.11.07		BRACKET A	SSEMBLY	1:1			



D3121-11 BRACKET

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) SHOP COPY MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi

RETURN TO ENGINEERING

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY

3) ALL DIMENSIONS ARE IN INCHES

SUBJECT TO AMENDMENT

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N & LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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W/O:		WORK ORDER CHANGES												
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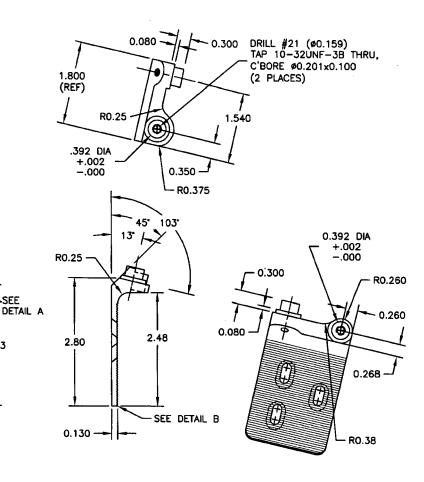
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0.400

1.280

0.960

0.330



D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N & LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

SHOP COPY RETURN TO

ENGINEERING

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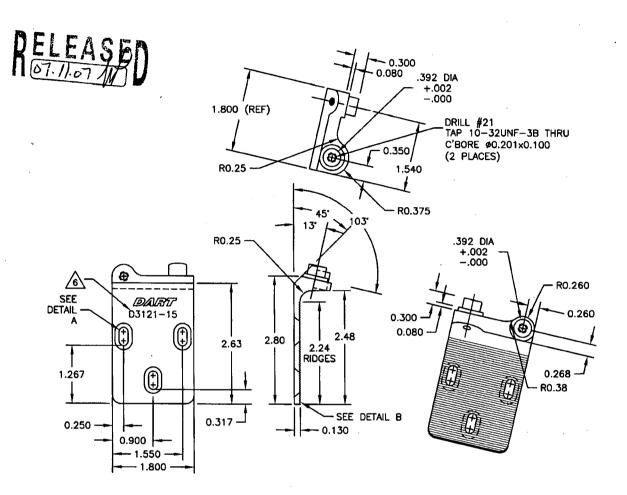
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07.11.07		BRACKET ASSEMBLY	1:2



D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) SHOP COPY MIN ULTIMATE TENSILE = 150 ksi **RETURN TO** MIN YIELD TENSILE = 100 ksi

ENGINEERING

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY SUBJECT TO AMENDMENT

3) ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE

- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

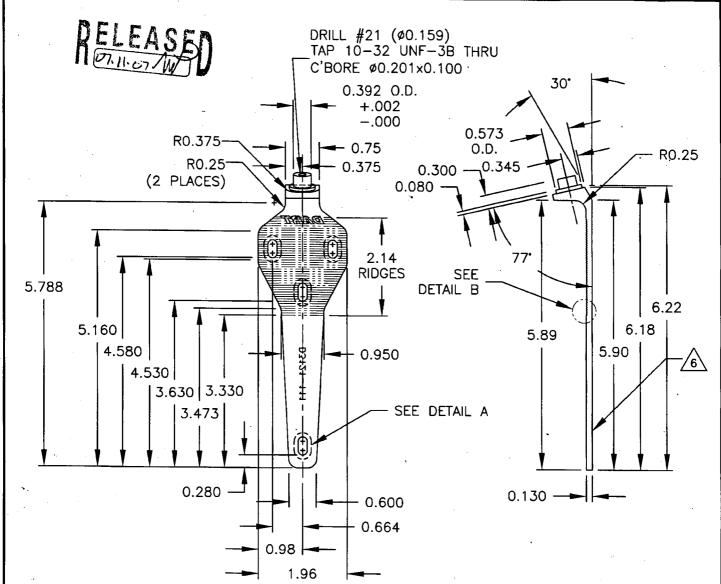
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917		D3121	SHEET 7 OF 10
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07.11.07		BRACKET ASSEMBLY	1:2



D3121-111 BRACKET

1) REPLACES PREMIER P/N B32-23001-11

2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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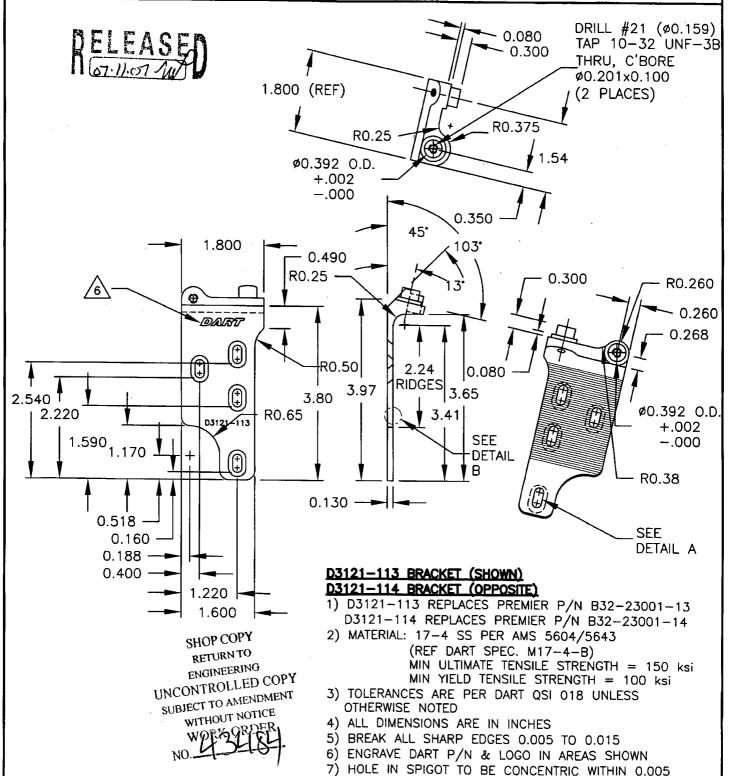
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07.11.07		BRACKET ASSEMBLY	1:2

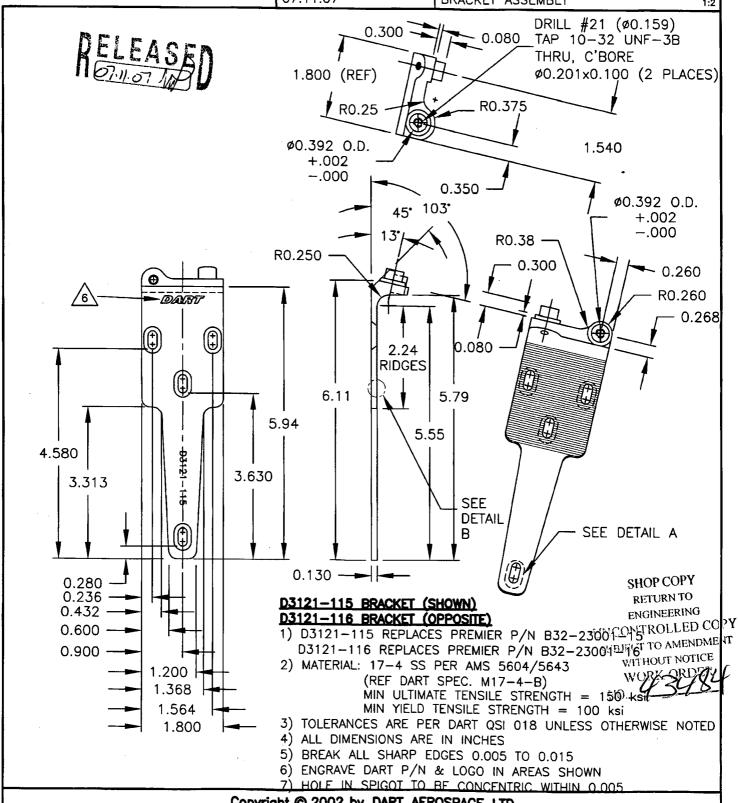


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	0777	Description of NC		Corrective Action Section	n B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector
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CHECKED	APPROVED	DRAWING NO.	REV. E
911		D3121	SHEET 9 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

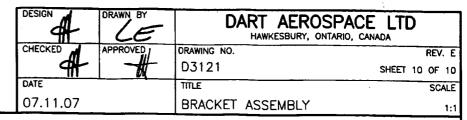


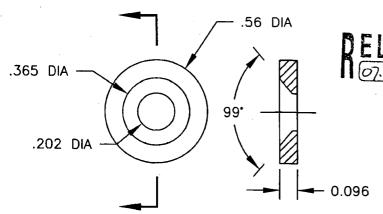
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W/O:			WORK ORDER	CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section	В	Verification	Annroyal	A				
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector					
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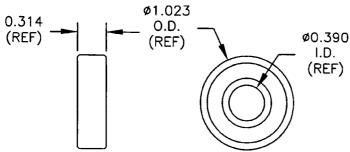






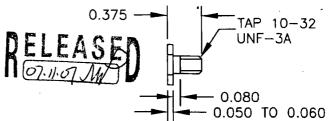
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



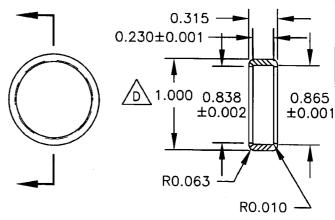
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

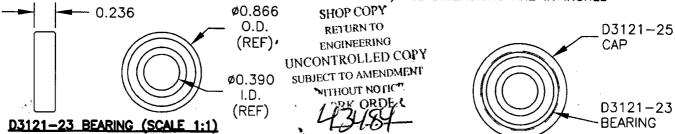


D3121-25 CAP (SCALE 1:1)

1) MATERIAL: DELRIN ROD, Ø1.25

(REF DART SPEC. M-DELRIN-R1.250)

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

D3121-241 BEARING ASSEBLY (SCALE 1:1)

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W/O: 😉		WORK ORDER CHANGES											
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